

Work Order ID 138234

138234

Tuesday, October 27, 2015 11:06:12 AM

Page 1

Ship
Dec 16th

Item ID: D3049-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw
 Start Date: 10/26/2015 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 10/26/2015 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLS Date: OCT 28 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3049	Rev A1								

110 0.00
 110
 Waterjet Memo 0.03
 FLOW CNC Waterjet CUT BLANK AS PER FILE D3049-1_BLANK
 (10) 12/15/12/03

120 0.00
 120
 HAAS 1 Memo 0.05
 HAAS CNC vertical machine #1 1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1
 3-Deburr
 10 15/12/16

130 0.00
 130
 QC Memo 0.00
 Quality Control
 10 15/12/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Page 2

ME
15-12-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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				OTHER :							

Picklist Print

Page 1

Tuesday, October 27, 2015 11:06:11 AM

Work Order ID: 138234

138234

Parent Item: D3049-1

D3049-1

Parent Item Name: Bearpaw

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No		120	sf	345.6000	3.4	13.6			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

38.5

02/15/12/03

Location

Loc Qty

Loc Code

MAT

84

m132063

84

MAT018

261.6

m133248

261.6

133642

7.5

31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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DART AEROSPACE LTD		Work Order: 138234
Description: Bearpaw		Part Number: D3049-1
Inspection Dwg: D3049	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	0,260	✓		MIP-04	vern
B	0.93	+/-0.030	0,930	✓		...	...
C	0.40	+0.030/-0.000	0,430	✓		MIP-08	Dial depth Mic
D	2.00	+/-0.030	2,000	✓		MIP-04	vern
E	10.250	+/-0.010	10,250	✓		...	...
F	4.540	+/-0.030	4,540	✓		↓	↓
G	5.88	+/-0.030	5,880	✓		↓	↓
H	0.38	+/-0.030	0,385	✓		↓	↓
I	11.50	+/-0.030	11,50	✓		↓	↓
J	0.07 x 45°	+0.030/-0.010	0,060	✓		↓	↓
K	0.44 - 0.47	+/-0.000	0,454	✓		↓	↓
L	R0.25	+/-0.030	0,250	✓		—	Radius gauge
M	0.38	+/-0.010	0,385	✓		MIP-04	vern
N	0.95	+0.030/-0.010	0,950	✓		↓	↓
O	0.69	+/-0.030	0,700	✓		↓	↓
P	0.20	+/-0.030	0,195	✓		↓	↓
Q	23.00	+/-0.030	23,000	✓		MIP-08	tape
R	0.25 x 45°	+/-0.030	0,250 x 45°	✓		...	...

DAS
45

Measured by: <i>[Signature]</i>	Audited by: 9-89	Prototype Approval:	N/A
Date: 15/12/15	Date: 2015-12-16	Date:	N/A

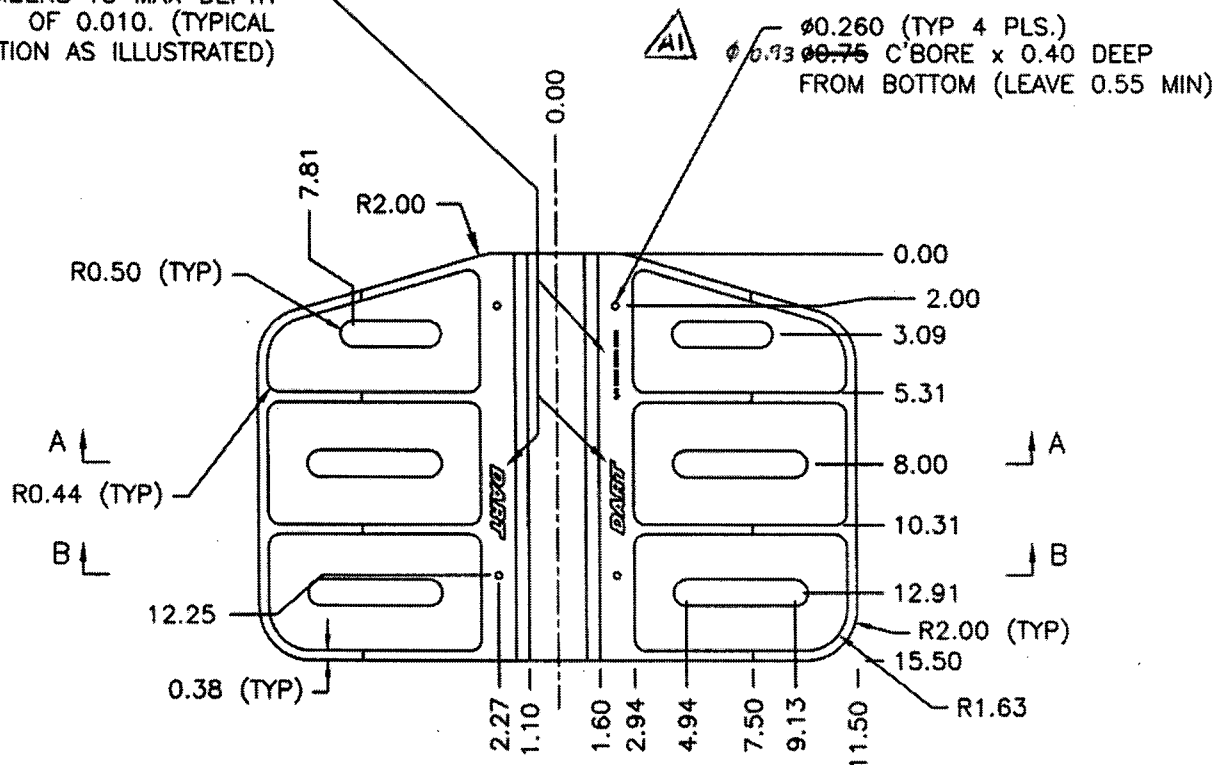
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18	TITLE BEARPAW		SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	# RF 03.01.13	Ø 0.93 WAS Ø 0.75	

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

STOP COPY
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WORK ORDER
138234145
15-10-28

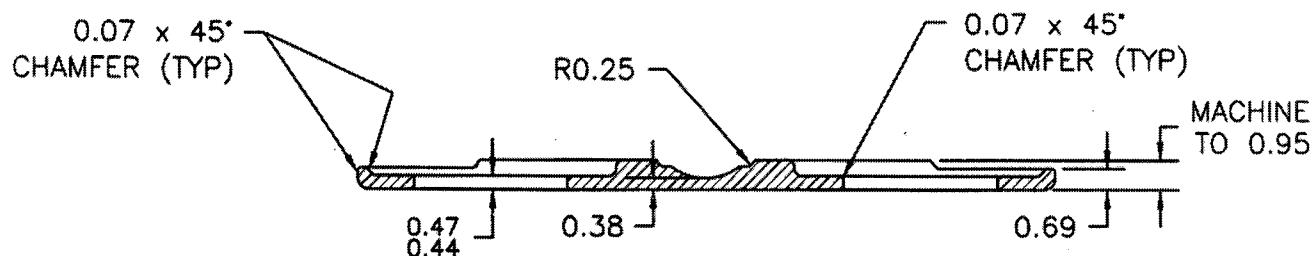
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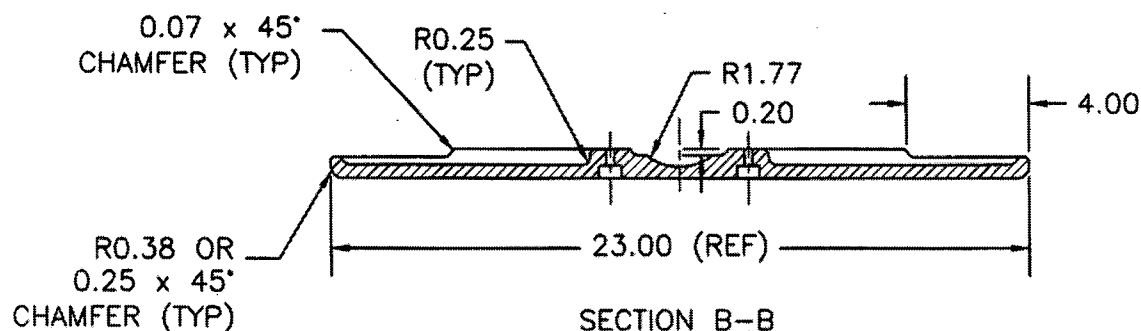


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 H



SECTION A-A



SECTION B-B

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